

Date: Thursday, 3/8/2007 1:17:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACEPOD BODY RH		
Job Number	: 31121B			Part Number	: D31882M		
Estimate Number	: 12596			Drawing Number	: D3188 REV.D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 3/8/2007	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 4/15/2007	Qty:	1
Previous Run	: 31086B			Um:	Each		
Written By	:						
Checked & Approved By	: <i>JK 07.03.08</i>						
Comment	: Est Rev:A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec						

Additional Product

*See
3091*

Job Number: 

Seq. #:	Machine Or Operation:	Description :		
1.0	D2213	Aluminum Spacer 		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Ship To Delastek				
8	D2213	Spacer	Batch:	
2.0	PG	PURCHASING 		
Comment: PURCHASING Issue P/O: _____ Description: D3188-2M BODY SHIP: D2213 Spacers Supplier: Delastek Conformity Certificate and Process sheet required Ship 2 Items from Previous steps				
3.0	D31882P	Spacepod Body 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Spacepod Body				
4.0	PACKAGING 1	PACKAGING RESOURCE #1 		
Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:17:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 31121B

Part Number: D31882M

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11/08/31

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN JB	DRAWN BY <i>CE</i>	DRAWING NO. D3188	REV. D
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DATE 07.02.22	SHEET 1 OF 11
		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

RELEASED
07.02.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINCELL
OR AIREX
OR KLEGECCELL
FILL Voids IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SCHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

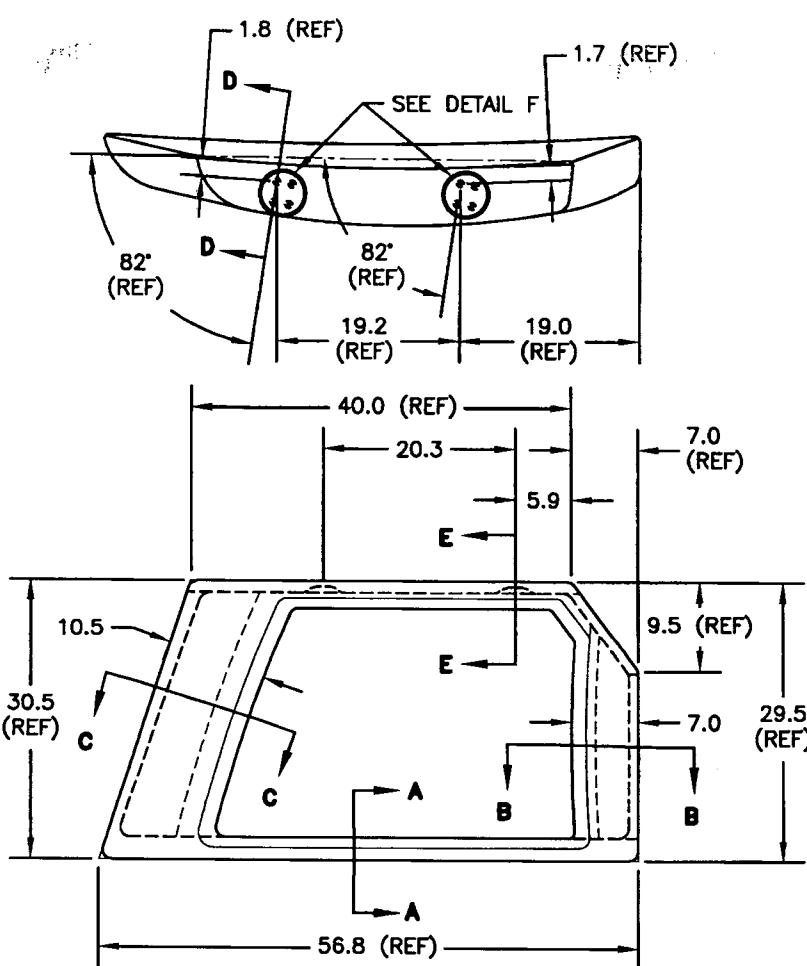
ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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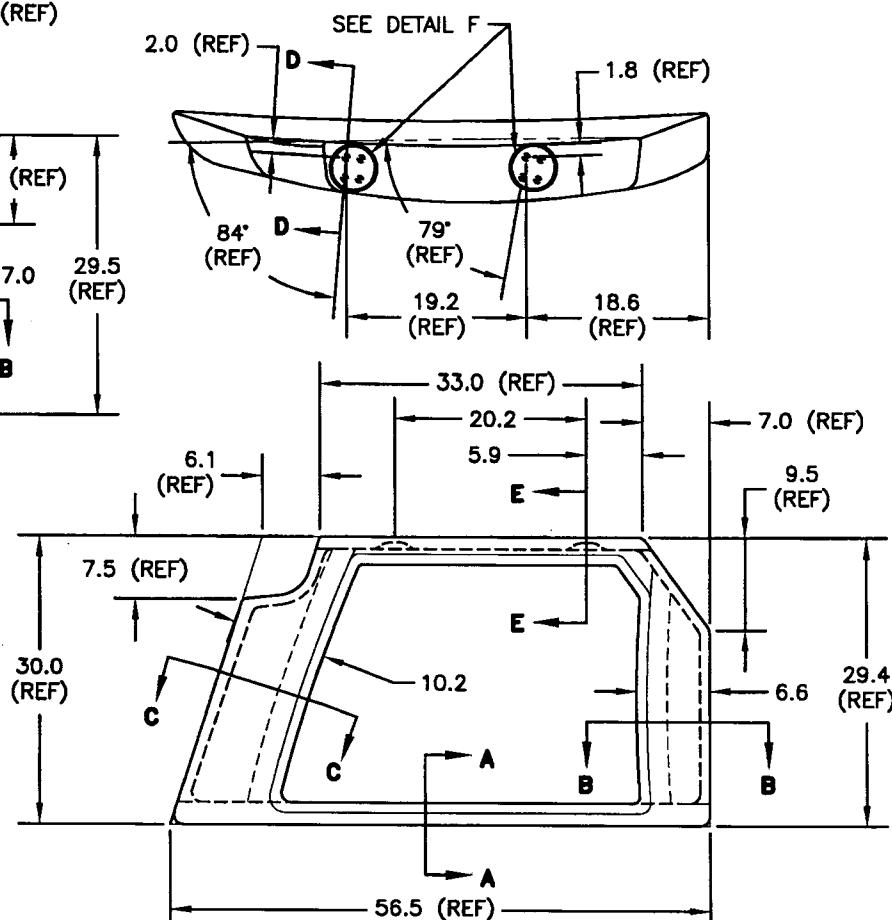
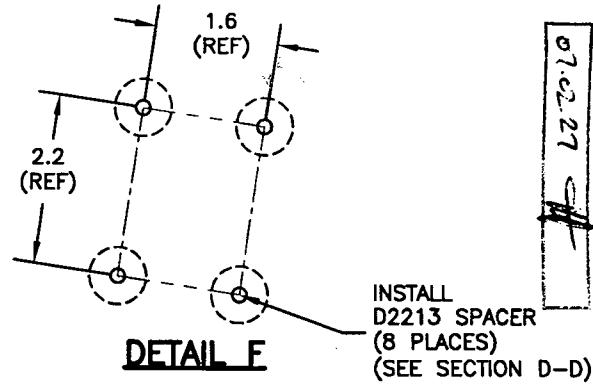
NO. *31121B*



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D3188-1M/-3M NOTES:

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.



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JB	CE	HAWKESBURY, ONTARIO, CANADA
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07.02.22		D3188
DATE		TITLE
		SPACEPOD BODY
		SCALE
		REV. D
		SHEET 2 OF 11
		NTS

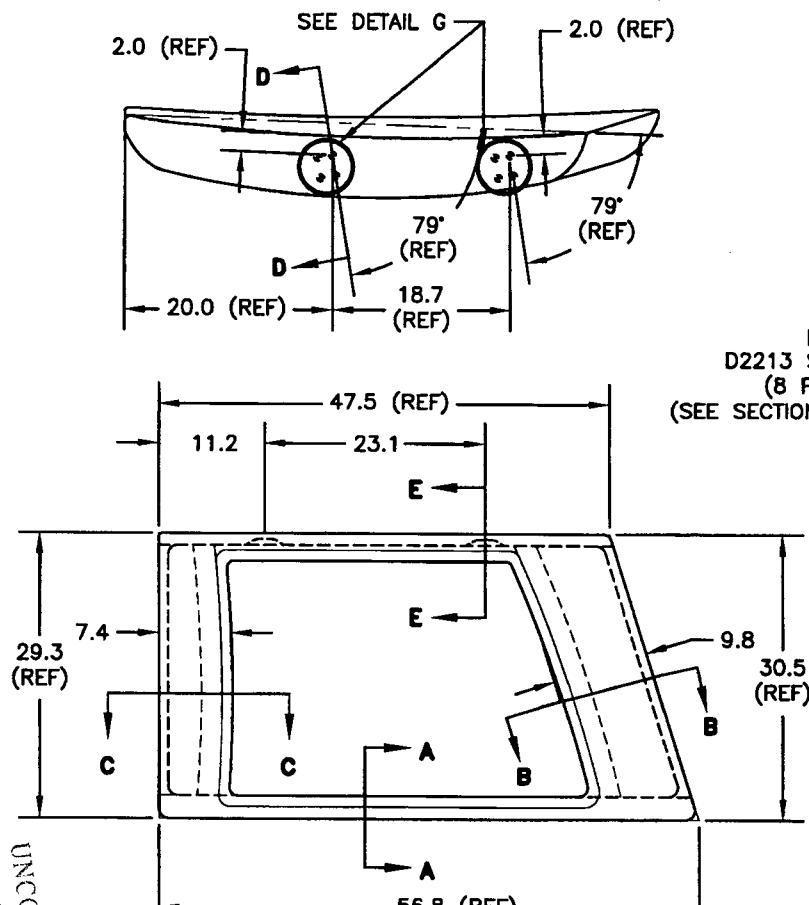
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DATE 07.02.22	TITLE SPACEPOD BODY	SHEET 3 OF 11 REV. D SCALE NTS

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le

**D3188-2M SPACEPOD BODY**

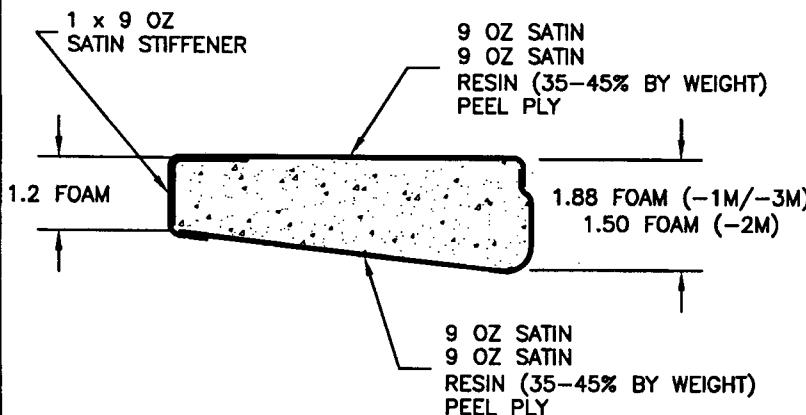
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D3188-2M NOTES:

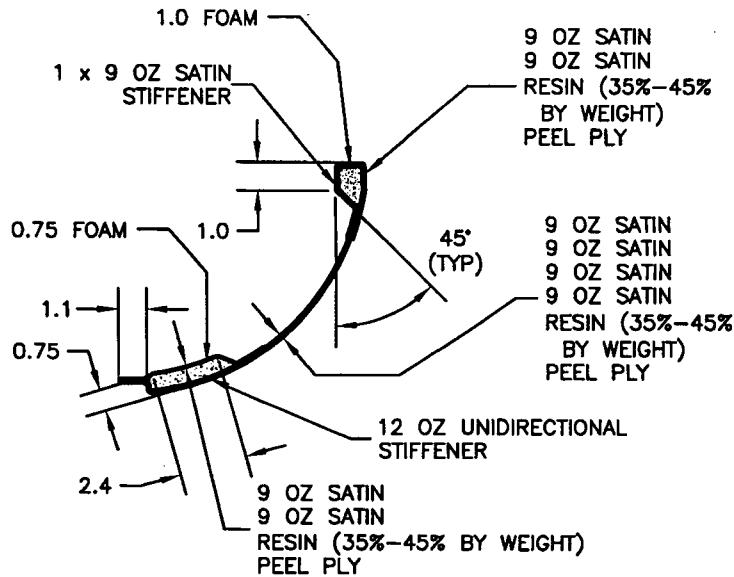
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2. SEE SHEET #4 FOR SECTION VIEWS.

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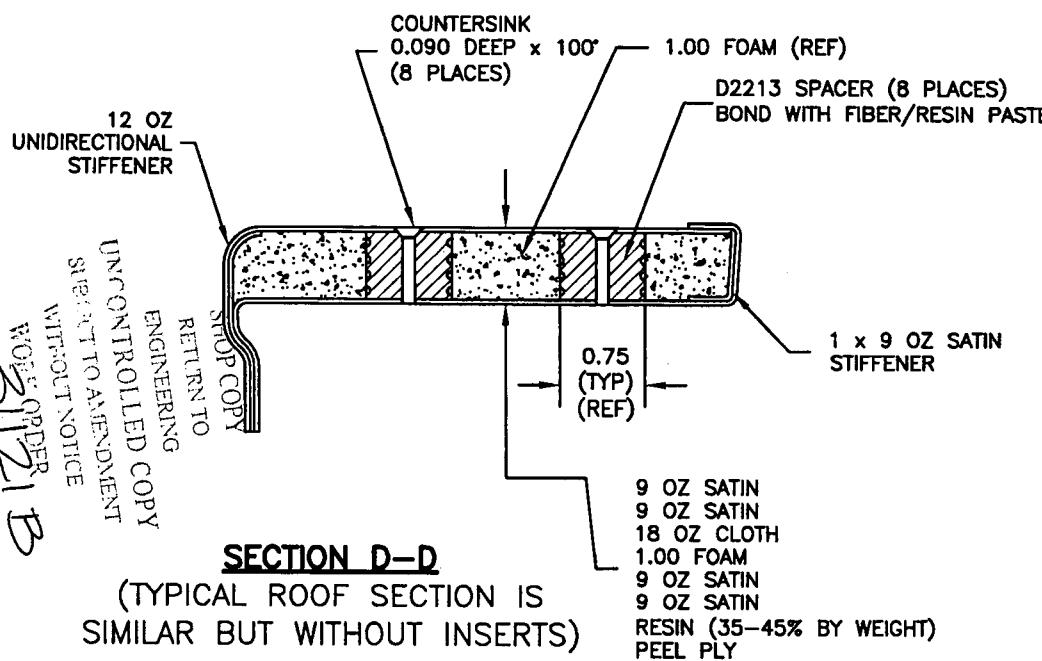
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DATE 07.02.22		TITLE SPACEPOD BODY	SHEET 4 OF 11	SCALE NTS



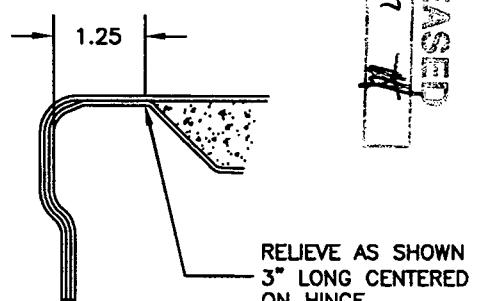
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)

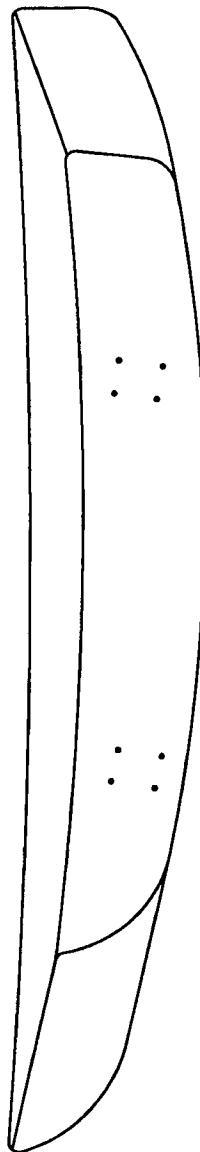


SECTION E-E
(2 PLACES PER POD)

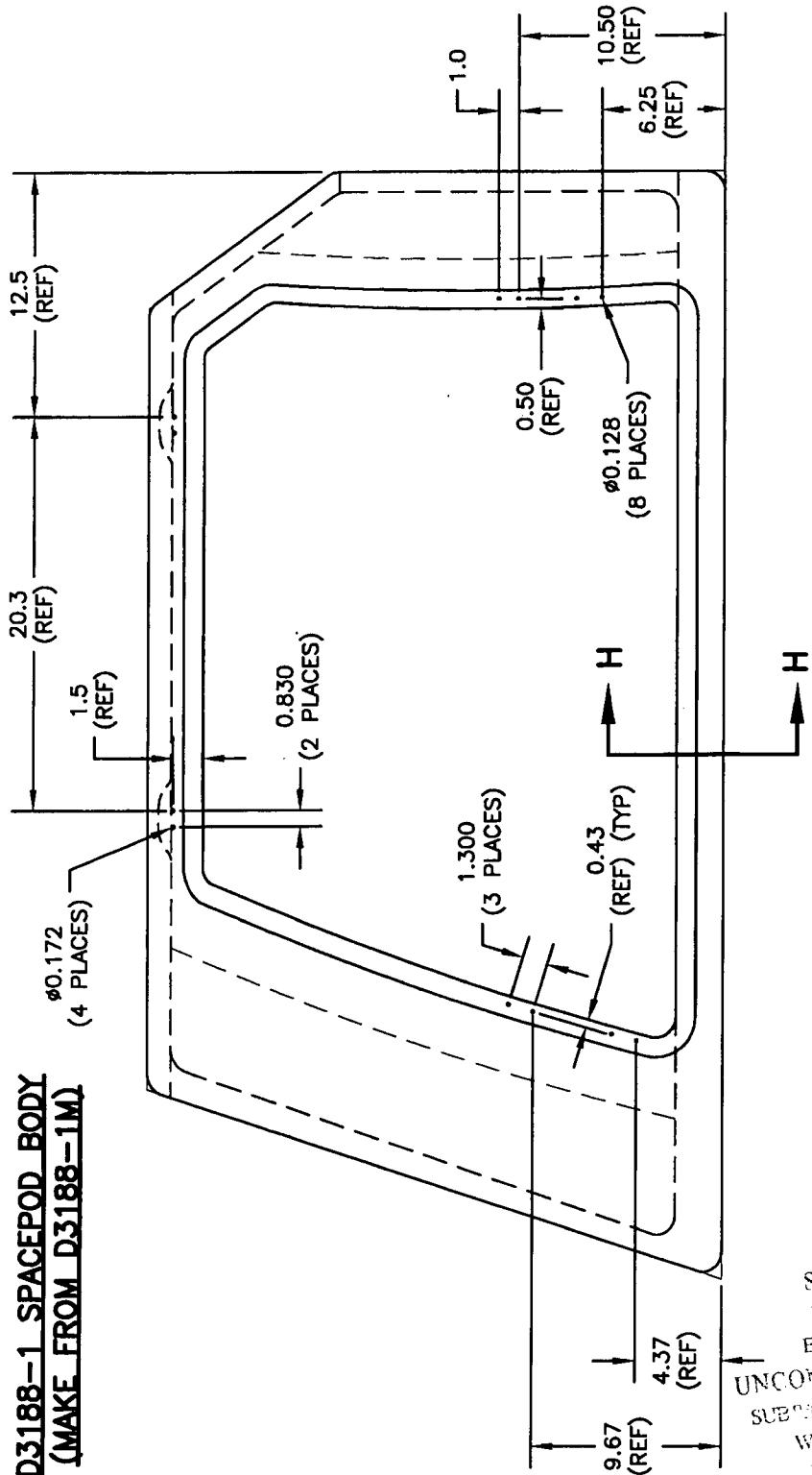
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.02.22 *AA*

**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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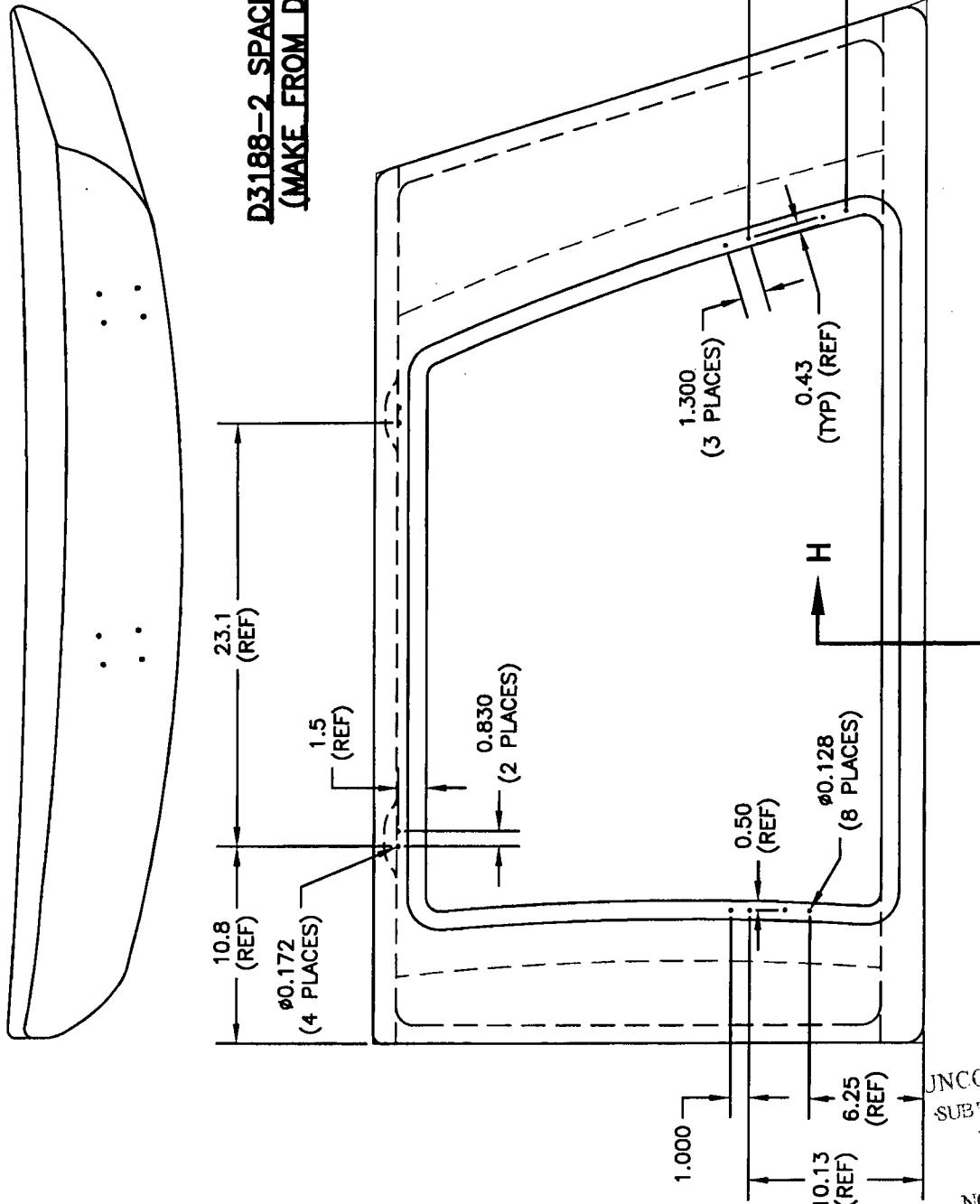
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.02.27 *CE*

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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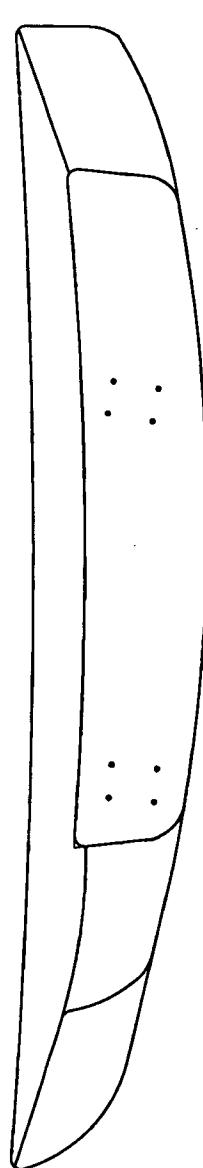
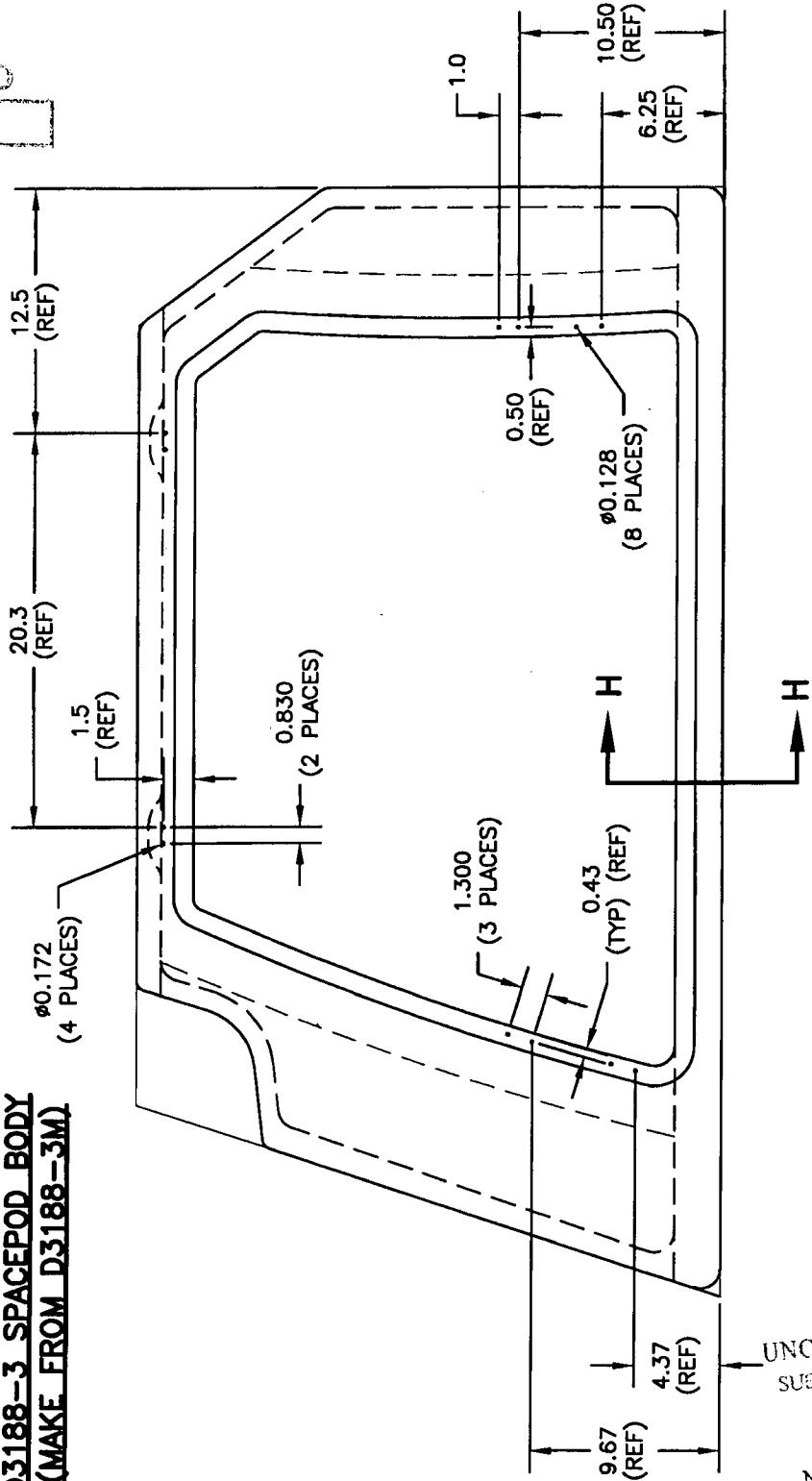
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DATE 07.02.22		REV. D SHEET 7 OF 11 TITLE SPACEPOD BODY SCALE NTS

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07.02.27 *HF***D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)****NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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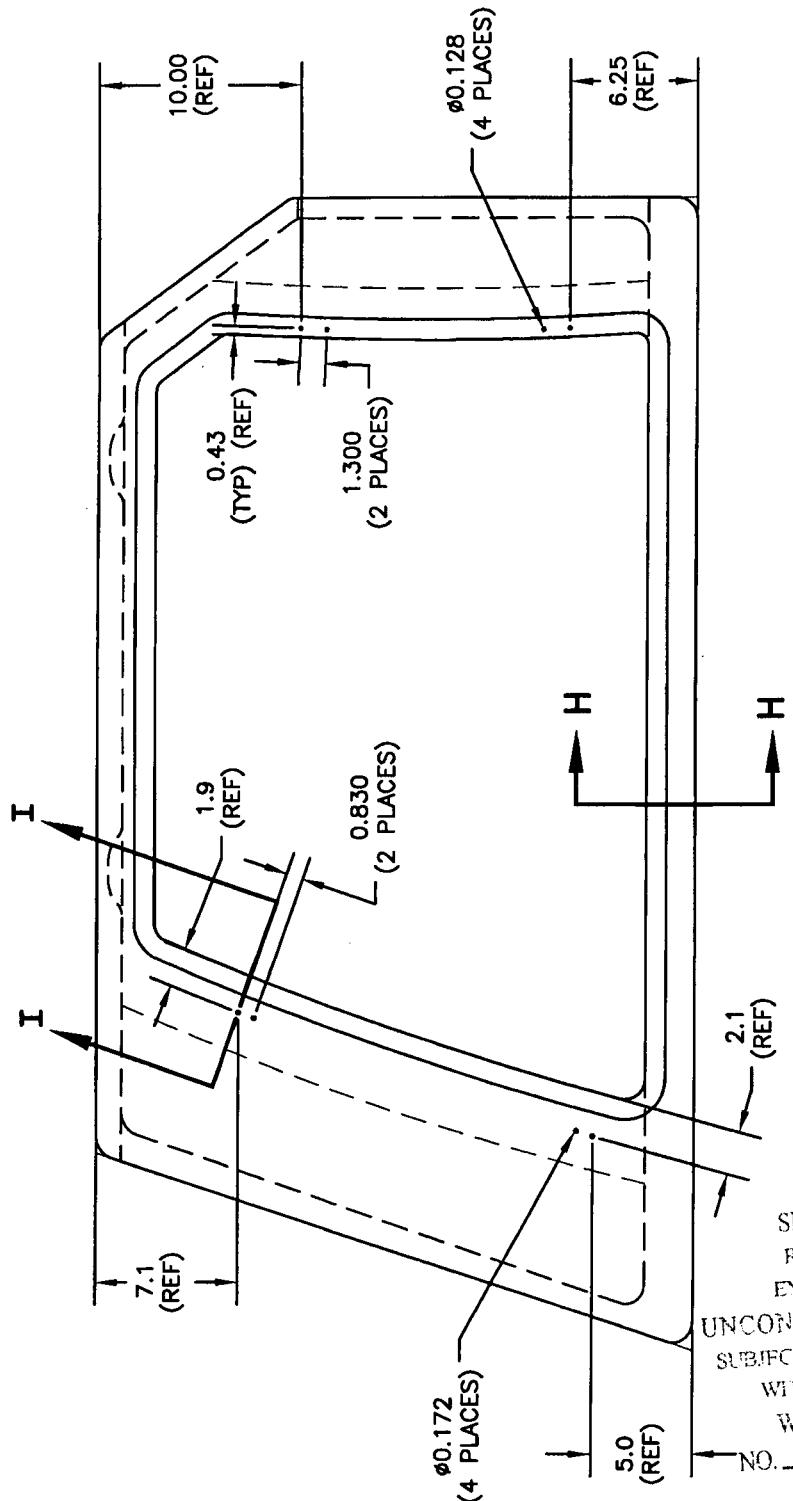
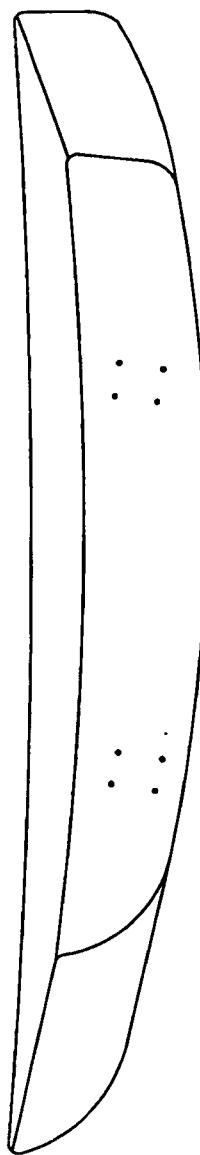
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**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)****NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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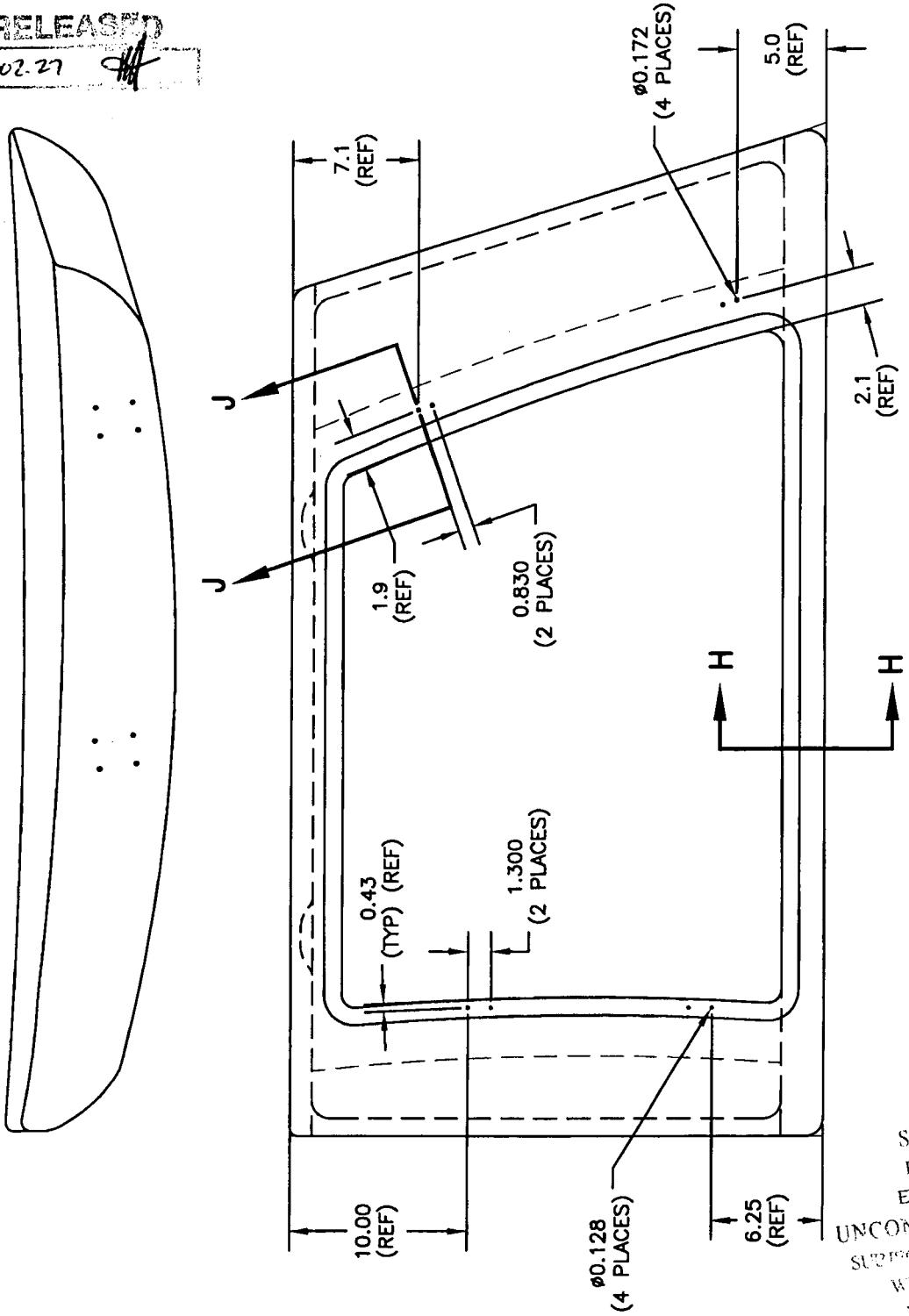
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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07.02.27

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)

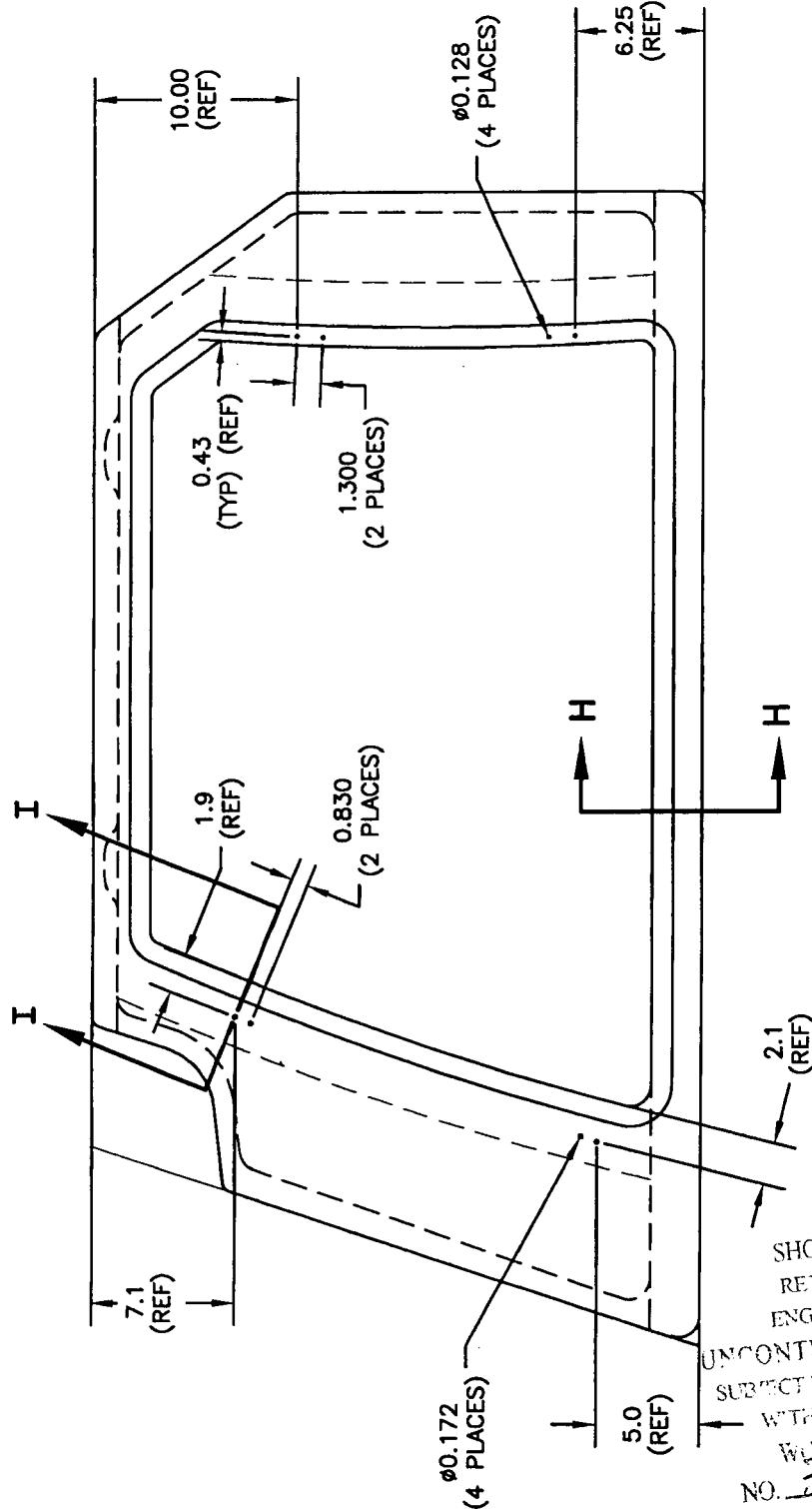
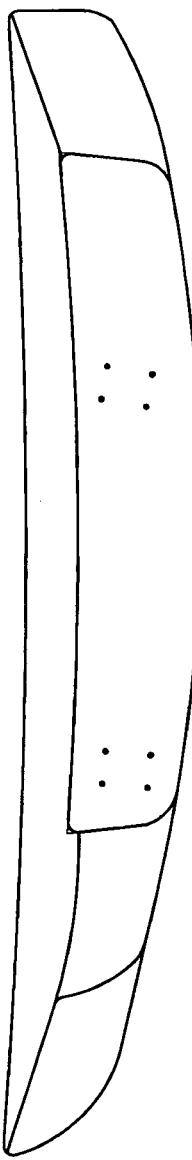
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07-02-27

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**

NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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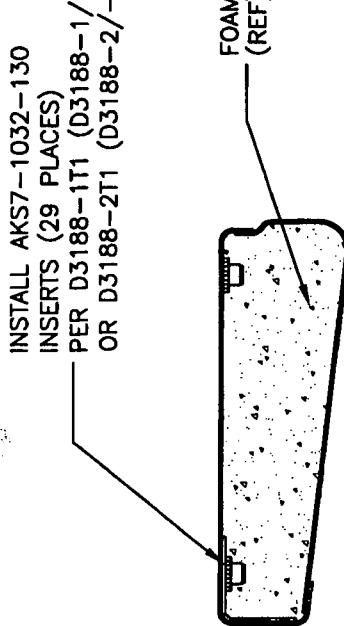
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

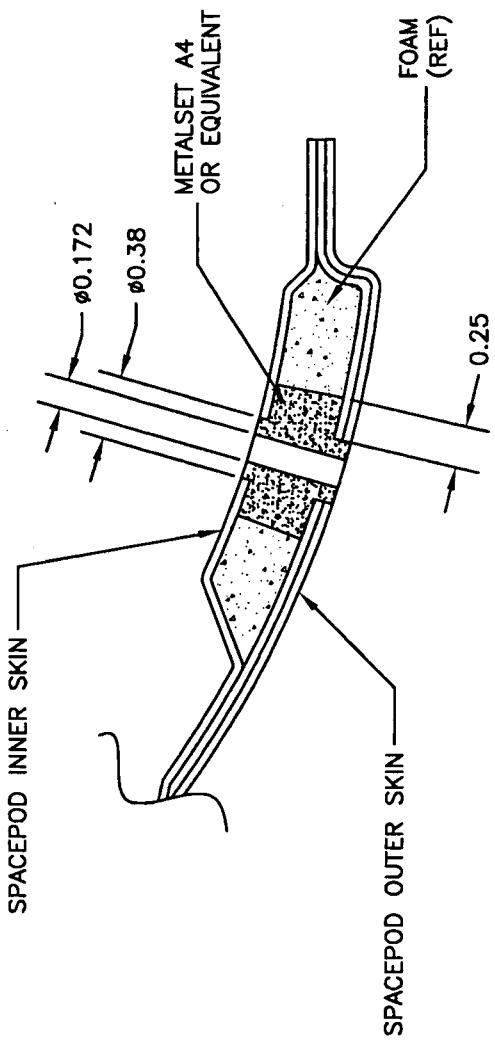
RELEASED

07.02.22 *CE*

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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